

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020652**Date Inspected:** 14-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

West Grillage:

Repair welding of weld joint no: SA7512L-257, complete joint penetration (CJP) weld. The welder is identified as 047864 and was observed welding in the 1G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ABF QA was identified as Ji Cai Feng. The welding variables appeared to comply with Welding procedure specification (WPS): 345-SMAW-1G(1F)-FCM-Repair-1. Repair welding was done as per Critical Welding Repair (CWR) Report: B-CWR 2629 Rev-3. See attached photo for details.

OBG Seg 13BW and Seg 13CW:

The Flux Cored Arc Welding (FCAW) process on weld joint no: OBW13A-016 (Corner Assembly to Deck Panel, CJP weld). The welder is identified as 201583 and was observed welding in the 1G position. ZPMC Quality

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Control (QC) was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-T-223(2)1T-ESAB.

Magnetic Particle Testing (MT) was observed to be done (y ZPMC MT personnel) after completion of root pass of this weld. See attached photo for details.

OBG Seg 13AW:

This QA Inspector observed ZPMC personnel performing free hand thermal cutting on X4368B and X4184B, of Floor Beam FB3176A (PP118) and FB3180A (PP118.35) respectively. The approximate length of this free hand thermal cutting was observed as 720mm. This QA informed this issue to ZPMC QC identified as Zhang Ling and ABF QA identified as Cao Hui Zhao. ZPMC personnel will be performing grinding on this thermal cutting area for proper bevel preparation. See attached photos for further details.

OBG Seg 14W:

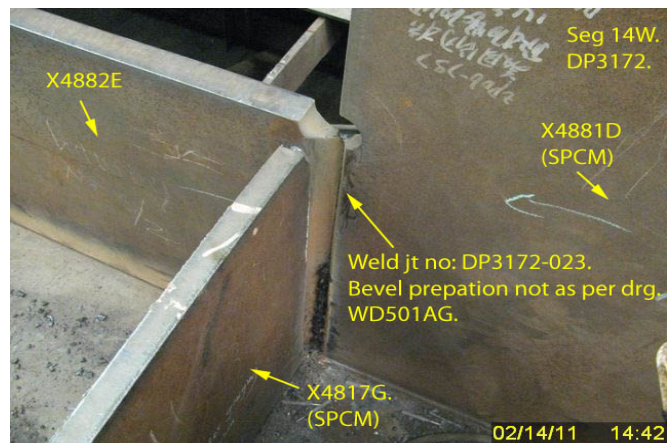
The SMAW process on weld joint no: DP3172-023 (X4882E to X4881D), CJP weld at PP127. The welder is identified as 066155 and was observed welding in the 3G position. ABF QA was identified as Shen Jian. However, this QA observed that the joint preparation is not as per the WD requirements of this weld. This QA inspector informed about this to ABF QA, identified as Shen Jian, and that an Incident Report would be raised. This was also informed to CT Design Engineer. See attached photos for further details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer